

Work Order ID 162854

162854

Page 1

Friday, June 16, 2017 8:10:53 AM

Item ID: D2873-043 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Nut Plate Assembly
 Start Date: 7/3/2017 Start Qty: 40.00 *40* Cust Item ID:
 Required Date: 7/13/2017 Req'd Qty: 40.00 *40* Customer:
 Reference:

Approvals: Process Plan: DAS 21 8-09 Date: JUN 16 2017 Tooling: SPC (Y/N): Date: Run Start *NR1*
 QC: Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2873	Rev A								

100 0.00 DAS 08 9-09
 100 BAND SAW
 Bandsaw Memo 0.45 B.A 17-06-17 40 φ
 Jeaspa Bandsaw Cut blanks: 1.000" x 0.375" x 3.700" long

110 0.50 DAS 08 9-09
 110 HAAS CNC VERTICAL MACHINING #1
 HAAS 1 Memo 4.52 B.A 17-06-17 40 φ
 HAAS CNC vertical machine #1 Machine as per Folio FA and Dwg D2873 Identify as D2873-3
 Dwg Rev A Folio Rev AA

120 0.00 DAS 08 9-09
 120 QC2- Inspect parts off machine FAI/FAIB
 QC Memo 0.40 B.A 17-06-17 40 φ
 Quality Control

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐								
		OTHER : _____							

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Page 2

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Nut Plate Assembly

Start Date: 7/3/2017 Start Qty: 40.00

40

Cust Item ID:

Required Date: 7/13/2017 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.80

Quality Control

40

0

DAS
14
9-89

17/06/20

140

Small Fab

0.00

140

Small Fab

Memo

0.97

Small Fab

1-Deburr 2- C'sink as per Dwg D2873

D. 17-06-17

40

0

DAS
08
9-89

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.80

Quality Control

40

0

DAS
38
9-89

11/06/2017

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WORK ORDER NON-CONFORMANCE / UPDATE



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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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162854

Friday, June 16, 2017 8:10:53 AM

N900040100

Setup Start *NS1*

Stop *NS2*

40

40

Reference:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

160

0.90

ue Qty Qty Number Stamp

X40  2017/06/22
BEB

170

0.40

40x 17/07/10 DAS 36 9-89

180

0.96

40x _____ 17/07/10 ^{DAS}
36
889

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : ☐									

Work Order ID 162854***162854***

Page 4

Friday, June 16, 2017 8:10:53 AM

Item ID: D2873-043 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Nut Plate Assembly
Start Date: 7/3/2017 Start Qty: 40.00 ***40*** Cust Item ID:
Required Date: 7/13/2017 Req'd Qty: 40.00 ***40*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.80				<u>40</u>			DAS 38 9-89 JUL 10 2017
200 *200* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo LOCATION : LG050	0.00 0.40				<u>40</u>	DAS 6 9-89		JUL 11 2017
210 *210* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 4.00							17/7/12 JH W17.07.11

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Picklist Print

Friday, June 16, 2017 8:10:52 AM

Page 1

Work Order ID: 162854

162854

Parent Item: D2873-043

D2873-043

Parent Item Name: Nut Plate Assembly

Start Date: 7/3/2017

Required Date: 7/13/2017

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP A05.09.13New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MS21075L5		Purchased	No			100	Each	69.0000	3	120			
MS21075L 5 Nut Plate													

Location Loc Qty Loc Code

GA 69
m137405 69

M6061T6B0.375X01.00 0		Purchased	No			180	f	37.8480	0.3083	12.98105			
--------------------------	--	-----------	----	--	--	-----	---	---------	--------	----------	--	--	--

M6061T6B0 375X01 000

6061T6 BAR .375 x 1.00

Location Loc Qty Loc Code

MAT 37.848
136036 2.26
m134984 1.288
→ m137762 34.3

MS20426AD4-6		Purchased	No			180	Each	570.0000	6	240			
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MS20426AD4-6

Rivet

Location Loc Qty Loc Code

GA 25
M134502 25
ST311 545
M136537 545

17/07/10
137951
120x

D.A 17-06-17

12.6981 ft

17/07/10
137851
240x

DAS
36
9-89

DAS
36
9-89

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Misidentified ☐	Past Due ☐																																																																

DART AEROSPACE LTD		Work Order: 162854
Description: Radius Block		Part Number: D2873-3
Inspection Dwg: D2873 Rev: A		Page 1 of 1

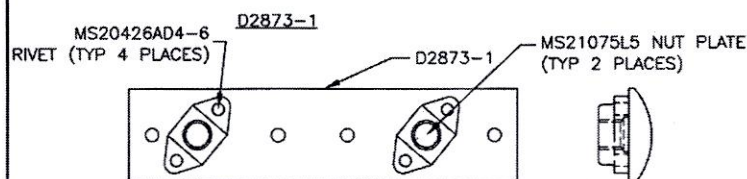
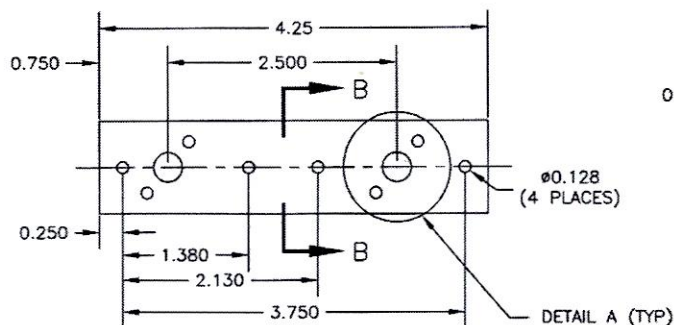
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

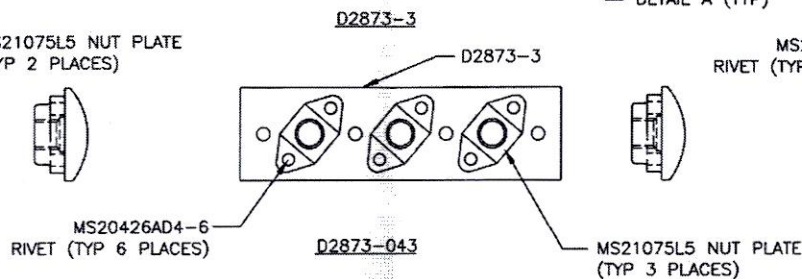
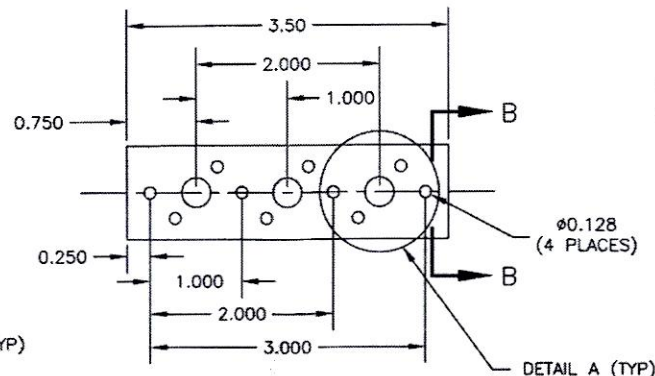
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.50	+/-0.030	3.500	✓		Vern	GA-B
2.000	+/-0.010	2.000	✓		"	"
0.750	+/-0.010	0.750	✓		"	"
1.000	+/-0.010	1.000	✓		"	"
0.250	+/-0.010	0.250	✓		"	"
1.000	+/-0.010	1.000	✓		"	"
2.000	+/-0.010	2.000	✓		"	"
3.000	+/-0.010	3.000	✓		"	"
Ø0.128	+0.005/-0.001	Ø0.129	✓		"	"
0.359	+/-0.010	0.360	✓		"	"
Ø0.316	+0.006/-0.001	Ø0.316	✓		"	"
1.000	+/-0.010	1.000	✓		"	"
0.250	+/-0.010	0.247	✓		"	"
0.061	+/-0.010	0.065	✓		"	"
Ø0.230 x 0.125	+0.005/-0.001 x 0.010	Ø0.230 x 0.126	✓		"	"
Ø0.225 x 100°	+/-0.010 X +/- 1/2°	Ø0.225 x 100°	✓		"	"

Measured by: D.A. DAS 08	Audited by: DAS 14	Prototype Approval: N/A
Date: 17-06-17 9-89	Date: 17/06/20 9-89	Date: N/A

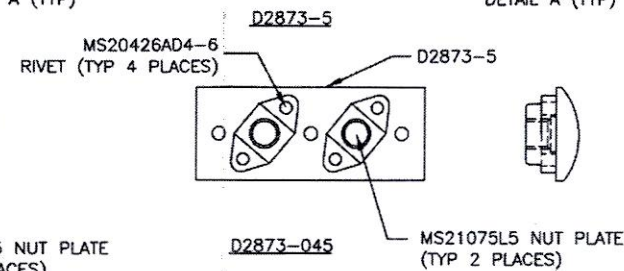
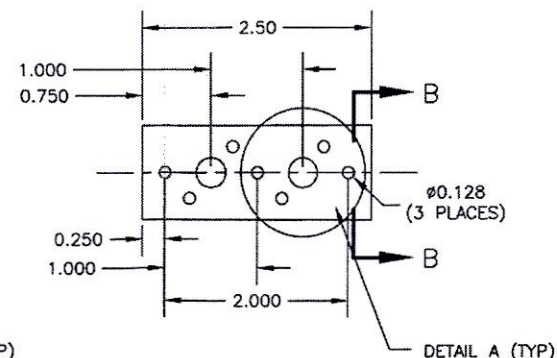
Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue P/O D2873-043	KJ/JLM	



D2873-041



D2873-043



D2873-045

D2873-1/-3/-5 RADIUS BLOCK

- MATERIAL: 5052-H32/H34 BAR (QQ-A-225/7) (REF. DART SPEC M5052H32B1.000X0.250) OR 6061-T6 BAR (QQ-A-225/8 OR QQ-A-200/8) (REF. DART SPEC M6061T6B1.000X0.250)
- FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- ALL DIMENSIONS ARE INCHES
- BREAK ALL SHARP EDGES 0.010 TO 0.020
- 0.128 PILOT + C'BORE CURVED SIDE 0.230X0.125 DEEP + C'SINK CURVED SIDE 0.225 x 100°

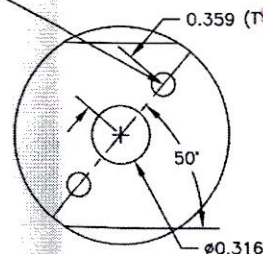
D2873-041/-043/-045 NUT PLATE ASSEMBLY

- INSTALL MS21075L5 NUT PLATE IN ORIENTATION SHOWN USING MS20426AD4-6 RIVETS

D2873-041/-043/-045 NUT PLATE ASSEMBLY PARTS LIST

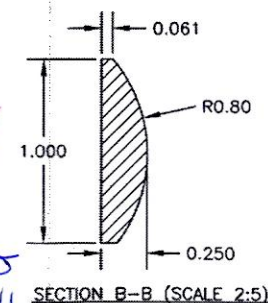
-041	-043	-045	PART NUMBER	DESCRIPTION
X			D2873-041	NUT PLATE ASSEMBLY
	X		D2873-043	NUT PLATE ASSEMBLY
		X	D2873-045	NUT PLATE ASSEMBLY
1			D2873-1	RADIUS BLOCK
	1		D2873-3	RADIUS BLOCK
		1	D2873-5	RADIUS BLOCK
4	6	4	MS20426AD4-6	RIVET
2	3	2	MS21075L5	NUT PLATE

6
(-041 4 PLACES)
(-043 6 PLACES)
(-045 4 PLACES)



DETAIL A (SCALE 2:5)

SPOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 162854
170616



SECTION B-B (SCALE 2:5)

RELEASED
05-07-26

A	05.07.26	NEW ISSUE
DESIGN	PH	DART DART AEROSPACE LTD WARRICKBURT, ONTARIO, CANADA
CHECKED	PH	DART
DATE	05.07.26	DRAWING NO. D2873
		TITLE RADIUS BLOCK
		REV. A SHEET 1 OF 1 SCALE 4:5